

Abstract:

The invention relates to a method for forming a sheet metal lid. At least one projection (20,21a,21b) is formed twice. Firstly for shaping a pre-form (20*) of the 5 projection out of a panel (10) of said sheet metal lid, said pre-form being located near an attaching portion (31) of a tab (30), but at a distance from said mounting place (11). Secondly for re-forming at least a front edge (20",21b') of said pre-form (20*) of said at least one projection. No score line (16) is provided in said panel, neither during shaping, nor during re-forming. An improved blocking for an outer edge portion (31c) of the 10 attaching portion is thus obtained, said outer edge portion being associated with said front edge.